

Day: Tuesday, 11/29/2005 3:04:23 PM
User: Linda Lacelle

Process Sheet

SPLIT

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number :	25017	Part Number :	D2572
Estimate Number :	10531	Drawing Number :	D2572 REV D
Part Number :	N/A	Project Number :	N/A
Issue :	11/29/2005 S.O. No. : N/A	Drawing Revision :	D
Rev. :	NC	Material :	N/A
Issue :	N/A Type : MACHINED PARTS	Due Date :	1/5/2006
Previous Item :	24838	Qty:	2 Um: Each
Written By :	SEE COMMENT BELOW		
Checked & Approved By :	SEE COMMENT BELOW		
Comment :	Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ		

Additional Product

Job Number :



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)
7075-T7351 8.25X5.0X2.5
Make from D6101-005 billet for D2572
Ensure that grain is along 5.00" length
Batch No: 152504

S.G. 06/01/29

2

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. 25017 Double check by: SA

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove shap edges.

S.G. 06/01/29

2

3.0	MILLING CONV	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2571 & D2572

S.G. 06/01/29

2

Process Sheet

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Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 25017

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description:

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.G

06/01/30

2

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BC

06.01.30

2

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FF 06-02-09

2

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MM 06 02 10

2

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/2/13 (2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5747

06/2/13 (2)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

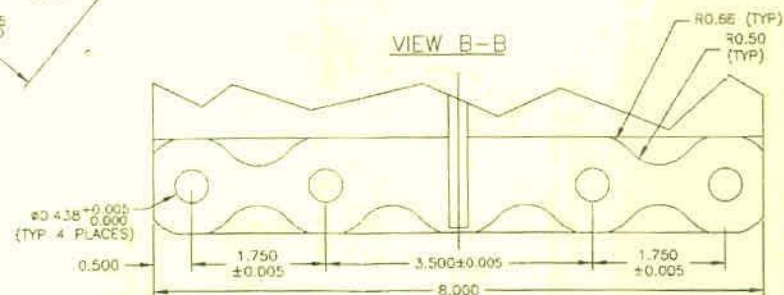
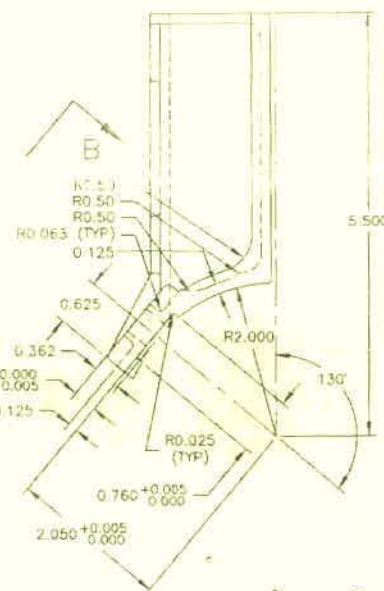
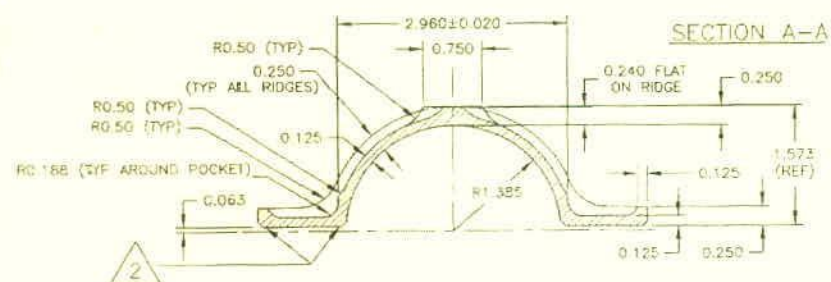
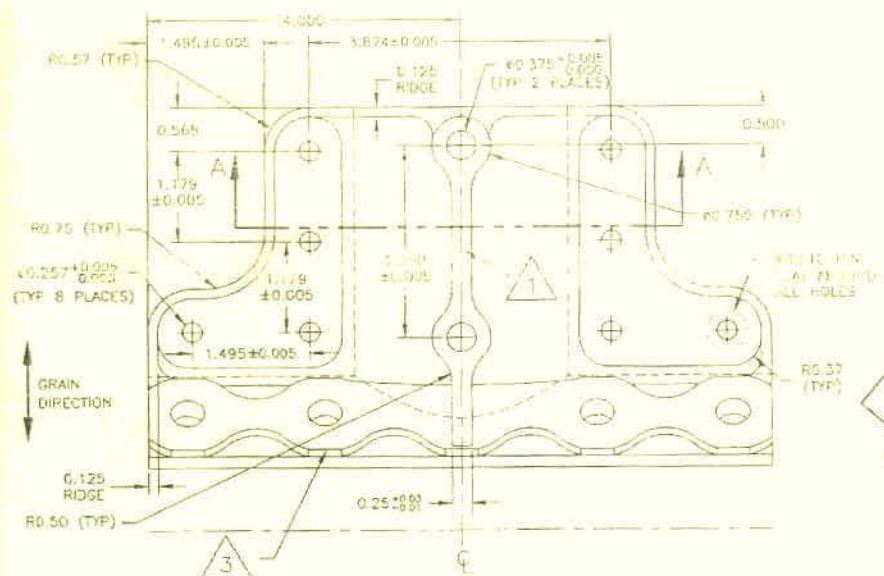
Inspection Level 21

595 06/02/14 (2)

06/02/14 (2)

Job Completion





NOTES

MATERIAL: 7075-T7351 (00-A-250/12)
 (REF DART SPEC D6102-003)
 FINISH: ADD FPM LUBRICANT PER DART OSI 005 4.1
 POWDER COAT GRAY-WHITE (REF 4.3.5.1) PER
 DART OSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND

D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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DESIGN	DRN BY	DART	DART AEROSPACE LTD.
CHECKED	APPROVED	DRAWING NO.	REV. 0
DATE		D2572	SHEET 1 OF 1
02.09.06		TITLE	SCALE
		INNER FWD SADDLE	2:3

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.501				
D	1.745	1.755		1.750	1.751				
E	7.990	8.010		8.002	8.003				
F	0.490	0.510		0.501	0.501				
G	0.257	0.262	DT8683	0.258	0.258				
H	0.375	0.380	DT8684	0.376	0.376				
I	0.490	0.510		0.500	0.501				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		0.569	0.568				
L	1.174	1.184		1.178	1.179				
M	1.490	1.500		1.494	1.495				
N	2.495	2.505		2.499	2.500				
O	3.869	3.879		3.873	3.872				
P	0.115	0.135		0.128	0.125				
Q	0.115	0.135		0.134	0.135				
R	0.240	0.260		0.245	0.246				
S	0.115	0.135		0.123	0.124				
T	0.178	0.198		0.188	0.188				
U	2.940	2.980		2.961	2.967				
V	0.230	0.250		0.249	0.248				
W	0.115	0.135		0.125	0.127				
X	0.307	0.312		0.311	0.311				
Y	0.760	0.765		0.761	0.761				
Z	0.352	0.372		0.362	0.362				
AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.630	0.632				
AC	0.053	0.073		0.063	0.063				
AD	0.240	0.260		0.255	0.254				
AE	1.375	1.395		1.377	1.377				
AF	0.115	0.135		0.135	0.135				
AG	0.240	0.280		0.261	0.261				
AH	0.240	0.260		0.250	0.251				
AI	2.000	2.020		N/A	N/A				
AJ	0.023	0.043		0.033	0.033				

Accept/Reject

Measured by:

Date: 06/01/20

Audited by:

BC

Date:

06.01.20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

